






Work Order ID 53549

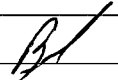


November 9, 2009 10:01:38 AM




Page 1


Item ID: D3838-042 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Rib Assembly (Basket Lid, RH)
Start Date: 09/11/2009 Start Qty: 2.00  Cust Item ID:
Required Date: 13/11/2009 Req'd Qty: 2.00  Customer:

Reference:


Approvals: Process Plan:  Date: 07-11-9 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3838	Rev A								

100
 Large Fab 0.00
Large Fab Memo 0.00
Large Fab 1- cut D3838-2 and D3838-3 rib as per dwg D3838-2- c'sink hole as per dwg
3- remove identification markings 4- deburr

110
 QC 0.00
Quality Control Memo 0.00

⇒ 802/11/16






QPL 09 11 13




Work Order ID 53549




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Page 2

Item ID: D3838-042 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Rib Assembly (Basket Lid, RH)
Start Date: 09/11/2009 Start Qty: 2.00  Cust Item ID:
Required Date: 13/11/2009 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  Large Fab	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838 <input type="checkbox"/> A/R ER316 S.S. Rod Batch: <u>H108775</u> <input type="checkbox"/> 2- grind weld flush where indicated on dwg D3838 <input type="checkbox"/> <input type="checkbox"/> 3- weld D3759-1 bushing as per dwg D3838 <input type="checkbox"/> 4-								<u>SP 09 11 18</u> (2x)
130  QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
Quality Control	Memo	0.00							<u>Cpl 09 11 18</u>
140  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							<u>=042</u> (2) <u>4</u>

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Item ID: D3838-042

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 09/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: WA

0.00

SAD 09-11-19(2)

Packaging

Memo

0.00

Packaging

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/19W 09.11.19

Picklist Print

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Work Order ID: 53549



Parent Item: D3838-042RevA



Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 09/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1RevA		Manufactured	No			100	Each	30.0000	2.0000			
Bushing												

SAD 09-11-13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

30

51473

30

2

M304TS0.750W.065

Purchased

No

120

f

607.5273 2.1720



SAD 09-11-13

304 SQ Tube .75x.75x.065W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

600

113082

600

Main Warehouse

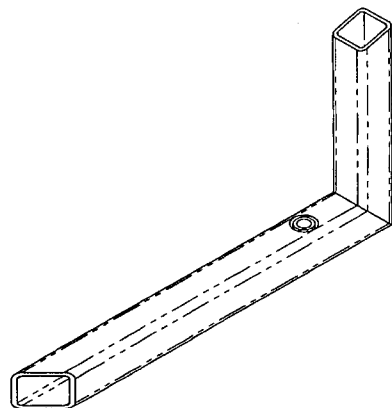
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7.5272947

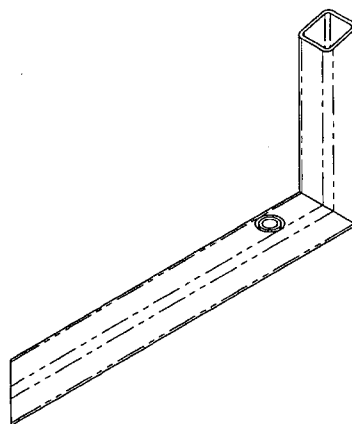
112398

7.5272947

2.1720



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK CENTER
NO. 53549

09-11-9

RELEASED
08/11/08

NOTES:

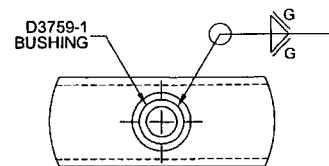
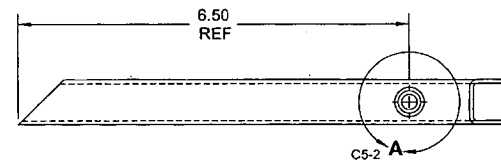
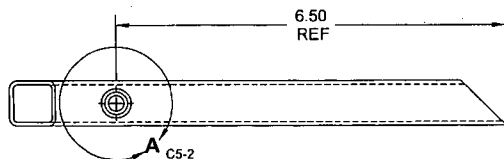
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.54 lbs

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		

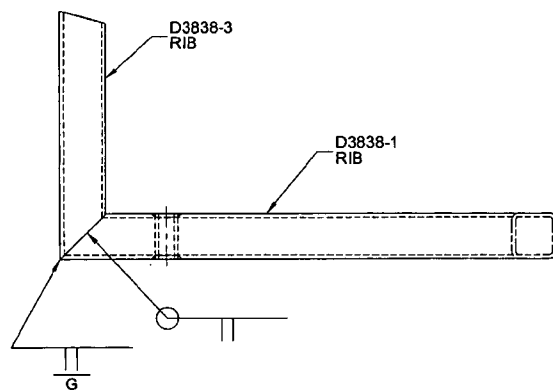
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
D3838 SHEET 1 OF 3
TITLE SCALE
RIB ASSY (BASKET LID) NTS

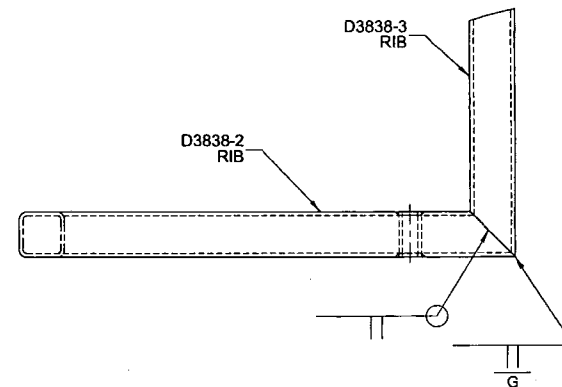
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DETAIL A
D2-2 SCALE 2X
D7-2



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, LH)

RELEASED
08/10/08

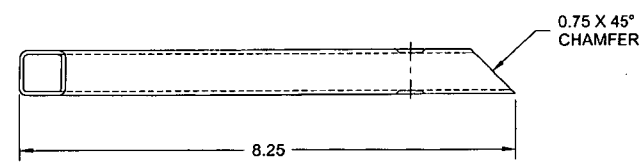
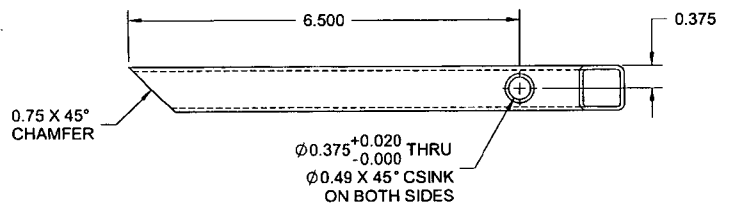
W1053549

DESIGN		DART AEROSPACE LTD	REV. A
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3838	SHEET 2 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		RIB ASSY (BASKET LID)	NTS
DE APPR.			
DATE	08.10.08		

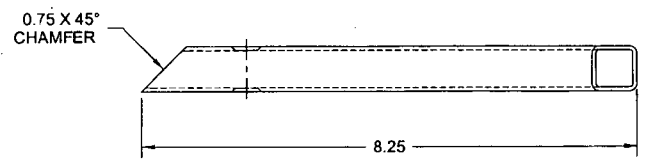
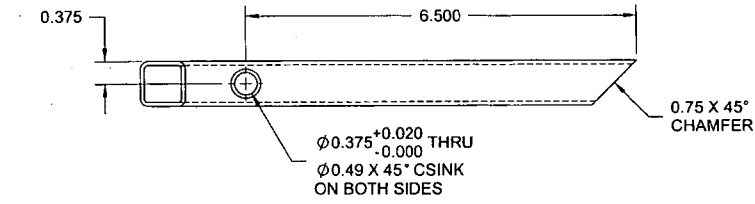
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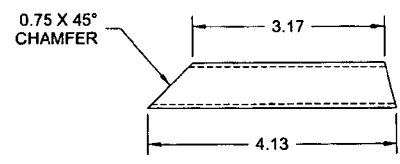
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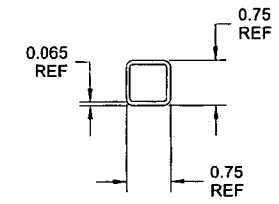
D3838-1 RIB



D3838-2 RIB



D3838-3 RIB



TYPICAL SECTION VIEW

B

B

A

A

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

RELEASED

W/053549

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3838	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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8 7 6 5 4 3 2 1